



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-312
Job Sheet 178928



Part No: D206-642-312

Job Qty: 1 ea

Part Name: Skidtube RH, Low & High Gear with Standard Wearplates



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/11/18

Job Tracking No:

Due Date: 7/6/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV Q SHEETS 29-30 IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC IPP Rev:K 07-12-04 ECN 1080p DD verified by:ec IPP Rev:L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev:M 09-03-02 as per DSI9440 rev.a verified by:EC IPP Rev:N 09-03-03 as per DSI9421 rev.b verified by:EC PP Rev:O as per REV.N DD 10.04.19 verified by:EC IPP Rev:P 12.11.21 ECN12-679 DD verf:JLM IPP Rev:Q 14.04.25 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/6/18	7/6/18	0.00	0.00	Start Up Stores/Pkg-1		
110	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging1-2	DEC 04 2018	DAS 69
120	QC	1 pcs	7/6/18	7/6/18	0.00	0.00	QC4		DAS 69
130	Packaging	1 pcs	7/6/18	7/6/18	0.00	0.00	Packaging3-1		DAS 69
135	DC	1 pcs	7/6/18	7/6/18	0.00	0.00	DC		DAS 21
140	QC21-FG	1 Ea	7/6/18	7/6/18	0.00	0.00	QC21		DAS 21

Part Op 130 - Identify and pack for shipping as per PPP D206-642-312
Descriptions: 135 - Photocopy bluefile and create labels per PPP D206-642-312 CHG008

DAS
21
9-89

DEC 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-41A	Bolt	8 Ea (8 ea)	90-Start up Operation	5038750
AN4-6A	Bolt	12 Ea (12 ea)	90-Start up Operation	5038750
AN4C5A	Bolt	1 Ea (1 ea)	90-Start up Operation	5019406
AN5-10A	Bolt	4 Ea (4 ea)	90-Start up Operation	5011095
AN5-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5003922
AN5-12A	Bolt	4 Ea (4 ea)	90-Start up Operation	5003726
D206-642-341	Replacement Skidtube (Fits LH or RH)	1 Ea (1 ea)	90-Start up Operation	B152762
D206-648-013	Ground Handling Wheel Modification	1 Ea (1 ea)	90-Start up Operation	5011780
D2652	Bushing	16 Ea (16 ea)	90-Start up Operation	5054609
D2712	Set Screw	10 Ea (10 ea)	90-Start up Operation	5031303
D2932-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	5059232
D2933-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	5059166174
D2934	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054580
D2935	Saddle Spacer	2 Ea (2 ea)	90-Start up Operation	5054580
D2938-2	Saddle RH Out, 206	1 Ea (1 ea)	90-Start up Operation	5059235
D2939-2	Saddle RH In, 206	1 Ea (1 ea)	90-Start up Operation	5059237
D3407-043	Tow Ring	1 Ea (1 ea)	90-Start up Operation	501159439
D3413-1	O-Ring	1 Ea (1 ea)	90-Start up Operation	5068698
D3456-1	Washer	1 Ea (1 ea)	90-Start up Operation	5079335
D3457-1	Washer	2 Ea (2 ea)	90-Start up Operation	5035437

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube
Part No. _____		Machining
NCR No. _____		Thermoforming
		Large Fab

Date : _____	Step #: _____	QTY Effect _____
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Description Work Order Deviation	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Container No: S089680
 Part: D206-642-312
 Job No: 178928
 Serial No/Batch: S089680
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: _____
 Date: 07/06/18

PROCESS Water Jet ☐ Eng. Coord. ☐ Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
MRB (QSI042) Approval	
Completed By	
Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval	

MS21042L3	Nut	8 Ea (8 ea)	90-Start up Operation
MS21042L4	Nut	12 Ea (12 ea)	90-Start up Operation
MS21043-4	Nut	1 Ea (1 ea)	90-Start up Operation
NAS1149C0463R	Washer	1 Ea (1 ea)	90-Start up Operation
NAS1149D0363J	Washer	8 Ea (8 ea)	90-Start up Operation
NAS1149D0463J	Washer	24 Ea (24 ea)	90-Start up Operation
NAS1149D0563J	Washer	8 Ea (8 ea)	90-Start up Operation

507867
 5062328
 5062296
 503933
 5015261
 5062379
 5068662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-41A	8	219	0
	AN4-6A	12	1,368	0
	AN4C5A	1	75	0
	AN5-10A	4	155	0
	AN5-11A	8	175	0
	AN5-12A	4	388	0
	D206-642-341	1	3	0
	D206-648-013	1	6	0
	D2652	16	501	0
	D2712	10	739	0
	D2932-2	1	3	0
	D2933-2	1	5	0
	D2934	2	72	0
	D2935	2	54	0
	D2938-2	1	4	0
	D2939-2	1	3	0
	D3407-043	1	24	0
	D3413-1	1	44	0
	D3456-1	1	337	0
	D3457-1	2	29	0
	MS21042L3	8	1,881	0
	MS21042L4	12	2,959	0
	MS21043-4	1	728	0
	NAS1149C0463R	1	253	0
	NAS1149D0363J	8	2,225	0
	NAS1149D0463J	24	5,122	0
	NAS1149D0563J	8	2,091	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
004244	S089650	AN3-41A	Bolt	S038750	ST347	8
004244	S089651	AN4-6A	Bolt	S058982	ST345	12
004244	S089652	AN4C5A	Bolt	S019407	ST345	1
004244	S089653	AN5-10A	Bolt	S017095	ST337	4
004244	S089654	AN5-11A	Bolt	S003927	ST338	8
004244	S089655	AN5-12A	Bolt	S003926	ST338	4
004244	S089656	D206-648-013	Ground Handling Wheel Modification	S077860	ST636	1
004244	S089657	D2652	Bushing	S054607	ST009	16
004244	S089658	D2712	Set Screw	S031303	ST010	10
004244	S089659	D2932-2	Saddle RH Out, 206	S059232	ST396	1
004244	F156174	D2933-2	Saddle RH In, 206		ST396	1
004244	S089660	D2934	Saddle Spacer	S054584	ST014	2
004244	S089661	D2935	Saddle Spacer	S054582	ST014	2
004244	S089662	D2938-2	Saddle RH Out, 206	S059235	ST395	1
004244	S089663	D2939-2	Saddle RH In, 206	S059237	ST396	1
004244	S089665	D3407-043	Tow Ring	F159457	ST530	1
004244	S089666	D3413-1	O-Ring	S068698	ST530	1
004244	S089668	D3456-1	Washer	S079335	ST036	1
004244	S089669	D3457-1	Washer	S035433	ST036	2
004244	S089670	MS21042L3	Nut	S078167	ST303	8
004244	S089671	MS21042L4	Nut	S062378	ST303	12
004244	S089672	MS21043-4	Nut	S062296	ST302	1
004244	S089673	NAS1149C0463R	Washer	S053953	ST266	1
004244	S089674	NAS1149D0363J	Washer	S015269	ST263	8
004244	S089676	NAS1149D0463J	Washer	S062379	ST263	24
004244	S089677	NAS1149D0563J	Washer	S068662	ST263	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 7/6/18 2:04 PM dart.quirion.sonia

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

ITEM	QTY -311	QTY -312	QTY -313	QTY -314	QTY -341	QTY -357	QTY -349	QTY -351	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-311	SKIDTUBE INSTALLATION, LH
		X								D206-642-312	SKIDTUBE INSTALLATION, RH
			X							D206-642-313	SKIDTUBE INSTALLATION, LH
				X						D206-642-314	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-341	SKIDTUBE
						X				D206-642-357	WEARSHOE KIT (REPLACES -347)
							X			D206-642-349	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-351	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D2650-5	SKIDTUBE ASSEMBLY
1								1		D4361-041	SKIDTUBE ASSEMBLY
2A					14			4		D2651-1	* PLUG ⁽¹⁾
2B					14			4		D2651-3	* O-RING ⁽¹⁾
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		MS27039-1-08	* SCREW ⁽¹⁾
5					2			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3-41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21042-3	NUT (OR MS21042L3)
12B	8	8	8	8						NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4	4	4						AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8	8	8						NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12	12	12						AN4-6A	BOLT
17	24	24	24	24						NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12	12	12						MS21042-4	NUT (OR MS21042L4)
20A					6	6				D3537-1	WEARPAD (REPLACES D2648-3)
21A					1	1				D3537-3	WEARPAD (REPLACES D3429-1)
22A					1	1				D4956-11	WEARSHOE (REPLACES D3535-11 + D3536-11)
23A					1	1				D4956-23	WEARSHOE (REPLACES D3535-23 + D3536-23)
24A					1	1				D4956-35	WEARSHOE (REPLACES D3535-35 + D3536-35)
26A					54	54				MS27039C1-08	SCREW
26B					54	54				NAS1149C0332R	WASHER (OR AN960C10L)
26C					54					ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34	1	1	1	1						AN4C5A	BOLT
35	1	1	1	1						NAS1149C0463R	WASHER (OR AN960C416)
36	1	1	1	1						D3413-1	RING (REPLACES D2655)
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER
40									2	D3414-041	GHW LUG (REPLACES D2659)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)

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Revision: Q

Date: 13.08.12

Change Record

PAGE 1 OF 1

Part Number: D206-642-311 /-311BL /-311G/-312/-312BL/-312G

Description: SKIDTUBE , LH/RH

[illegible]

